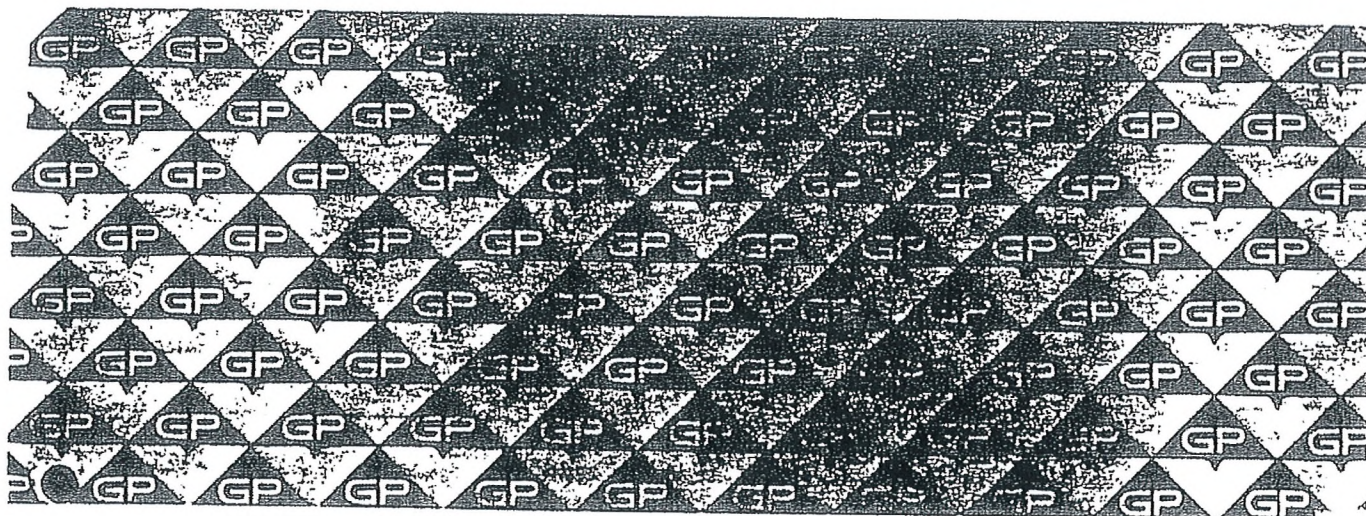


JOINT SYSTEM PRODUCTS

FOR
GYPSUM WALLBOARD

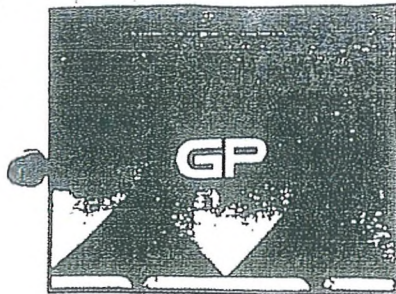


GEORGIA-PACIFIC / GYPSUM DIVISION



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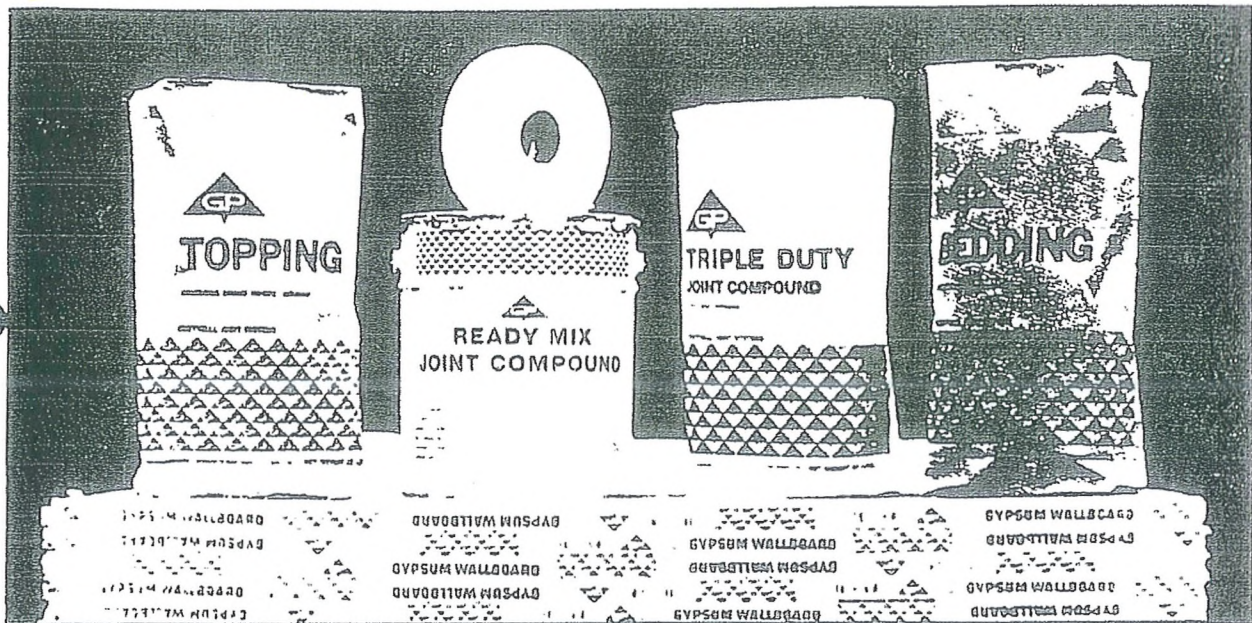
Georgia-Pacific Joint Treatment
Products conform to ASTM
Specification No. C475-64
and Federal Specification No.
SS-J-570.



GEORGIA-PACIFIC

JOINT SYSTEM PACKAGING

Joint System Products relate to gypsum wallboard in the same manner wood moldings relate to hardwood paneling. Whenever you sell or quote on gypsum wallboard your immediate second thought should relate to a sale or quote on joint compound to use with the board. This is not only good selling but profitable for all concerned. When this initial effort is made by you with a customer, you will find that future orders will automatically include the joint system products and result in a nice increase in the amount of the billing and the percentage of profit. A good rule-of-thumb is "for every 1,000 square feet of gypsum wallboard you sell, you should also sell, as an accessory item, 60 pounds of a joint system product."



PACKAGING COLORS

Product	Weight	Bag Color	Lettering Color
Triple Duty	25 & 50 lb.	White	Blue/Green
Ready Mix	1 & 5 gal. (pails)	White	Blue/Green
Bedding	25 lb.	Kraft	Red
Topping	25 lb.	Kraft	Blue
All Purpose Joint Compound	18 & 25 lb.	Kraft	Brown
Speed Set	25 lb.	White	Orange
Bestex A	25 lb.	Kraft	Blue/Green
Bestex B, C and D	40 lb.	Kraft	Blue/Green



GEORGIA-PACIFIC

JOINT SYSTEM PRODUCTS

Joint System is the material with which gypsum wallboard joints are reinforced and concealed to provide a smooth monolithic surface that will accept various types of decoration.

Joint System Products are classified into two broad categories—those made with a casein base and those made with a vinyl base.

Triple Duty and Ready-Mix are vinyl based material. All of the remaining products are casein base materials. The only exception is Speed Set, which is a gypsum base material.

The following pages give detailed information concerning the use of G-P Joint System Products.



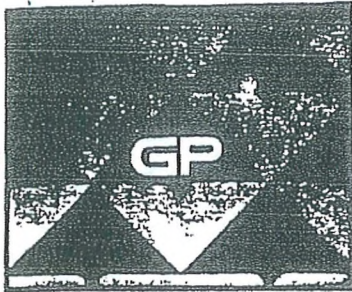
TRIPLE DUTY JOINT COMPOUND

G-P/Bestwall Triple Duty Wallboard Joint Compound is a vinyl multi-purpose joint system product. A single bag offers taping, topping and texturing. It can be used for all coats in the reinforcing and concealing of joints in gypsum wallboard construction. The binder in Triple Duty, being a vinyl, gives this product a wet life of 30 to 60 days duration. This allows pre-mixing in large quantities prior to application. Triple Duty can be applied using standard hand or mechanical tools. The product has low shrinkage and it is easily sanded. When the application is completed, the surface is ready for priming and decoration as desired, with no further preparation necessary. Coverage: 60 lbs. per 1,000 square feet (12-50 lbs. per 1,000 square feet when used as a texturing material). Available in 25 and 50 lb. bags.

BEDDING

Bedding Compound is designed to provide maximum adhesion of tape to the joints, and for the initial application to nail heads and corner bead. It spreads smoothly and may be hand or machine applied. Since it is used for this express purpose, we are able to build in the maximum taping and adhesive qualities necessary. Coverage: 15 lbs. per 1,000 square feet. (Used in conjunction with 45 lbs. of Bestwall Topping Compound.) Available in 25 lb. bags.





JOINT SYSTEM PRODUCTS



TOPPING COMPOUND

Topping Compound is specifically designed for the second and third coats over the Bedding Compound. Since it is used only for topping, we are able to reduce the amount of adhesive and incorporate other raw materials which makes it easier to sand, work better and possess lower shrinkage. Coverage: 45 lbs. per 1,000 square feet. (Over 15 lbs. of Bestwall Bedding Compound.) Available in 25 lb. bags.

ALL PURPOSE JOINT COMPOUND

All Purpose Joint Compound is used for bedding tape, topping, corner beads, nail spotting and texturing. When taping be sure each coat or layer of compound is thoroughly dry before applying succeeding coats. When used for texturing, for best results, apply a vinyl primer to the entire area before texturing. The texture may be applied with a roller, sponge, brush or other suitable implement depending on the type of configuration desired. Coverage: 60 lbs. per 1,000 sq. ft. Available in a 25 lb. bag and an 18 lb. bag with a 250' roll of tape.



Many dealers who purchase joint systems products require the following items to service their painting, retail and do-it-yourself trade customers:

Joint Compound	5 lb. boxes
Joint Compound	4 lb. box with 60' tape
Patching Plaster	5 lb. boxes
Spackling Compound	5 lb. boxes

As a general rule, the same class of customer will, also, be purchasing one gallon cans of Ready-Mix and the 18 lb. bag of Joint Compound, which includes a 250' roll of tape.



JOINT SYSTEM PRODUCTS



READY-MIX

Ready-Mix Joint Compound is a prepared wet mix material designed to bond tape to wallboard for joint concealment—to fill and finish joints—cover and finish nail heads and corner bead.

Controlled formulation and mixing results in:

- greater coverage
- savings in job mixing
- easy sanding—smooth working
- uniform consistency

Ready-Mix can be stored almost indefinitely and still provide a workable, crack-resistant finish.

Available in either machine or hand tool consistency. It is packaged in one gallon or five gallon pails. Coverage: 1-5 gal. pail per 1,000 sq. ft. of wallboard.

Application:

It is best to use the Ready-Mix compound at pail consistency to minimize shrinkage. If a thinner material is desired, Ready-Mix can be easily thinned with water using a potato masher type mixing paddle. A drill type mixer is not recommended as this tends to whip air into the compound. Add the water gradually to speed the thinning process. Cool or lukewarm water should be used. Do not use hot water. If overthinning occurs, simply add additional Ready-Mix compound to thicken and then remix.

When storing the wet mix in a pail for prolonged periods, cover the mix with a damp cloth or a thin layer of water. When reusing, pour off water and remix.

Ready-Mix joint cements are formulated so that they will not be useless in the event of freezing, unless it has been frozen and thawed several times, or subject to extremely low temperatures. If the material becomes frozen, allow it to thaw at room temperature. Do not force the thawing process. When Ready-Mix freezes and thaws, the cement generally settles out at the bottom of the can. In event this occurs, the cement should be thoroughly mixed ensuring that the bottom layers have been mixed throughout. Following this, water may be added to obtain the desired consistency, and cement should be thoroughly remixed as before.

Decoration:

For best results a prime coat should be used over the entire wallboard surface before final decoration.



JOINT SYSTEM PRODUCTS

SPEED SET JOINT COMPOUND

DESCRIPTION

Georgia-Pacific Speed Set Joint Compound is a vinyl gypsum adhesive to be used for taping, finishing joints, concealing nail heads, and corner beads.

Speed Set comes 2 ways:

1. With a 1 hour working time which sets up hard in 1 hour 30 minutes. It will be identified on the bag in inch high red letters "1 hour working."
2. With a 2 hour working time which sets up hard in 2 hours 30 minutes. It will be identified on the bag in inch high red letters "2 hour working."



Mixing

Add 25 lbs. of G-P SPEED SET to 1½ gallons of clean (potable) water with continuous mixing. Allow to soak a minimum of 5 minutes. Remix, adding water if necessary to obtain proper working consistency. The mix may tend to stiffen slightly for as much as 10 minutes after it is mixed.

Application

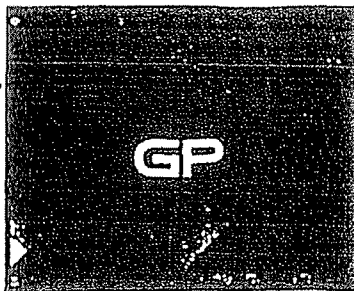
Apply G-P SPEED SET to joints and embed tape, leaving a uniform thickness under the tapes. Fill corner beads and spot nail heads. Apply finish coats over tapes, corner beads and nail heads after previous application has hardened (set). As an alternative, G-P Triple Duty or Ready-Mix may be used for finishing.

Precautions

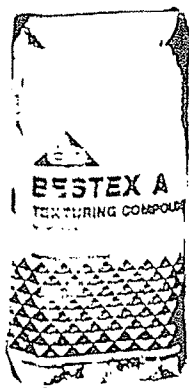
1. Do not mix more material than can be applied in one hour.
2. Do not mix with other joint compounds in either wet or dry form.
3. Clean tools and mixing equipment after each batch to prevent acceleration of setting time.
4. If stiffening occurs, except within the first 10 minutes, setting action is starting and material should be discarded.
5. Do not retemper mix—never add part of a previous batch to a fresh batch.
6. Minimum air, water, mix and surface temperature of 55° must be maintained in working areas until joints are completely dry.

Decoration

For best results, a prime coat should be used over the entire wallboard surface before the final decoration. If an oil base primer is used, be sure the entire surface is thoroughly dry before application.



SPECIALTY JOINT SYSTEM PRODUCTS



BESTEX TEXTURING COMPOUND

Bestex is a texture finish that produces hard, white surfaces that have excellent light reflective qualities and hiding power. Bestex A has no aggregate, B has a small amount of fine aggregate, C has a heavy amount of aggregate, and D has a coarse aggregate, creating a simulated acoustic effect. The B, C and D textures are for spray application only. Bestex A is available in 25 lb. bags, Bestex B, C and D are available in 40 lb. bags.

Surface Preparation:

Bestex™ A, B, C and D. All surfaces, including joint system applications, must be dry and clean. Roughen glossy surfaces. Prime any exposed metal surfaces with a rust inhibitor. Fill and seal any wood surfaces. For best results, it is recommended that a vinyl primer or equivalent be applied to the entire surface prior to texturing.

Coverage:*

Bestex A: 12 to 50 lbs. per 1,000 square feet of gypsum wallboard depending upon texture pattern.

Bestex B, C and D: Each 40 lb. bag finishes approximately 300 to 500 square feet of gypsum wallboard.

Application:

Bestex B, C and D. Apply with conventional spray texture apparatus as product warrants. Continuously agitate the mix when spraying to avoid separation or settling. For best coverage and uniformity of texture, spray a given area first in one direction, and then immediately double back at right angles to this application. Air pressure in spraying equipment will affect degree of texture. For coarser texture, use less air pressure, for finer texture, use more air pressure.



JOINT SYSTEM PRODUCTS

APPLICATION METHODS

G-P Bedding and Topping Compound is a 2-bag system. Bedding is used for the initial coat and Topping is the recommended material for all succeeding coats.

G-P Triple Duty, Ready-Mix, All Purpose and Speed Set are 1-bag systems and may be used independently for all steps in the treatment of drywall joints, nails and screws and corner bead applications. It is preferable to use Topping Compound or Triple Duty for the final coat over Speed Set Joint Compound.

AILS AND SCREWS



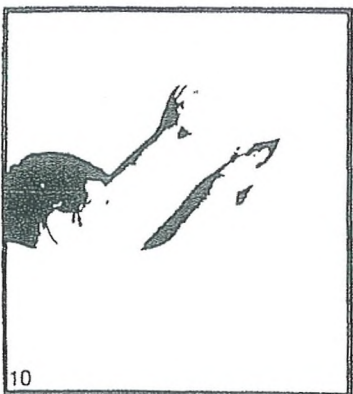
1. Draw finishing knife across nail and screw heads to be sure they are all driven to proper level. Apply first coat of embedding type compound (G-P Bedding, Triple Duty, Ready-Mix, All Purpose or Speed Set) over the nail or screw head. Apply ample pressure on knife to smooth compound to surface level of the board. Do not bow blade with excess pressure as this tends to scoop compound from the dimpled area.
2. When dry, apply second coat (G-P Topping, Triple Duty, Ready-Mix, Joint Compound or Speed Set) with even knife pressure to ensure complete coverage.
3. When second coat is dry, sand lightly and apply third coat. Depending on humidity, temperature, etc., additional coats may be required. Light sanding may be necessary before applying decoration.

TAPERED JOINTS



1. Apply G-P embedding type joint compound (G-P Bedding, Triple Duty, Ready-Mix, All Purpose or Speed Set) fully and evenly into the valley formed by adjoining tapered edges of G-P Gypsum Wallboard. When using machines, tape and compound are applied in one operation.
2. Center G-P Wallboard Tape and press into compound with a drywall knife held at approximately a 45° angle. Draw knife along tape with sufficient pressure to squeeze some compound from edges of tape, yet leaving enough for a sufficient bond.
3. Apply a fill coat extending a few inches beyond edges of tape and feather edges of compound. The purpose of this coat is to conceal the tape and fill the portion of the valley not filled by the tape.
4. When dry (24 hours or longer), apply a second coat and feather the edges about 1½" beyond first coat, with a wide knife. Use G-P Topping, Triple Duty, Ready-Mix or All Purpose Speed Set may be covered as soon as compound sets.
5. When dry, sand lightly and touch up any imperfections. Wipe off dust from sanding in preparation for the decoration.

END JOINTS

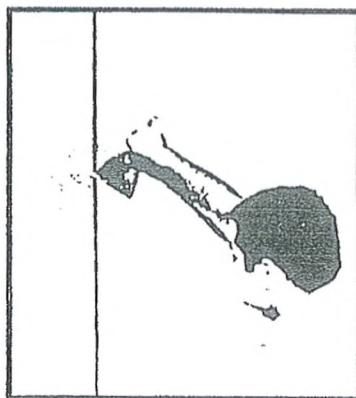


1. The end or butt joints are not tapered so care must be taken to leave sufficient joint compound underneath the tape to ensure a good bond between the tape and the board.
2. Apply a fill coat as described for tapered joints and feather compound 1 inch beyond edge of tape. When thoroughly dry the second coat is feathered 1 to 2 inches beyond edges of skim coat if necessary. Third coat feathered 2 inches beyond edges of second coat may be applied. The total application of joint compound is approximately 14 to 18 inches wide. Alternately end joint may be finished with a coat on each side of the tape but covering each edge. Another coat is subsequently applied to cover the center of the tape.
3. The object in finishing the end joint is to keep the center build-up of joint compound as low as possible since a high crown encourages ridging and shadowed areas.



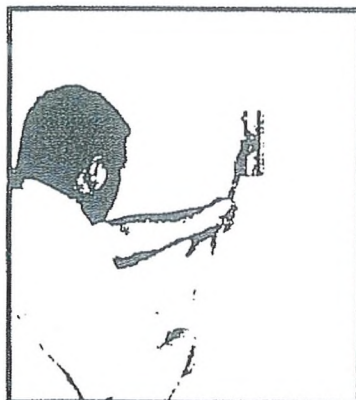
JOINT SYSTEM PRODUCTS

APPLICATION METHODS



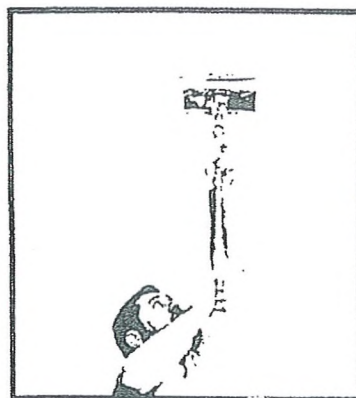
METAL BEAD

1. Be sure the metal bead is firmly attached. Fasteners are not protruding and the bead is thoroughly cleaned. Use embedding type joint compound (G-P Bedding, Triple Duty, Ready-Mix, All Purpose or Speed Set) for application over the bead.
2. Cover both flanges completely using the bead as a screed. Smoothly spread the compound 3 to 4 inches wide from the nose of the bead.
3. When dry, sand lightly. If necessary, and apply second coat (G-P Topping, Triple Duty, Ready-Mix, All Purpose or Speed Set) feathering edges 2 to 3 inches beyond first coat. Depending on quality of work desired and job conditions, a third coat or more may be required. Feather the edges of each coat beyond the preceding coat.
4. When the final coat is dry, sand carefully before proceeding with the decoration.



TAPED ANGLES

1. Using either a drywall knife or corner tool, spread embedding type joint compound (G-P Bedding, Triple Duty, Ready-Mix, All Purpose or Speed Set) on both sides of the interior angle. Be sure there is complete coverage and that the compound extends 1 1/2" on each side of the angle.
2. Fold G-P Tape along the middle crease and embed in the compound. Press each side of the tape alternately, with sufficient pressure to squeeze compound from edges of tape. Feather compound 2" from edge of tape.
3. When dry, apply a second coat (G-P Topping, Triple Duty, Ready-Mix, All Purpose or Speed Set) with a corner tool coating both sides of angle at the same time. Alternate method is to apply second coat with a square edged knife, one side of angle at a time or both sides together feathering compound 1 1/2" each side of tape. If third coat is necessary, apply when second coat is dry, feathering 1 inch beyond the edges of the second coat. Sand finish coat lightly, then it is ready for application.
4. To prevent hairline cracking, use a minimum amount of compound at apex of angles.



TECHNIQUE

1. The recommendations of the various tool manufacturers should be used to get best results in mechanically applying joint compound.
2. When mechanical tools are used, generally the width of feathering on joints is 2" for each coat.
3. Each coat must be dry before subsequent coats are applied.

CAUTION—Topping Compound must never be used to embed tape mechanically or by hand.

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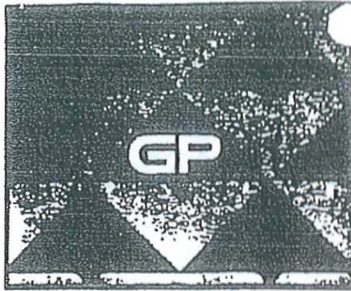


JOINT SYSTEM PRODUCTS

GENERAL SALES DATA

Problems Which Can Occur in Joint Treatment

Joint Treatment Conditions	Cause	Remedy or Prevention
Short Working Cement	Insufficient soaking time; that is, the cement may not be in solution so that optimum plasticity is not reached.	Allow sufficient soaking time (at least 20 minutes)
Cement Settles in Pail	Dirty or contaminated buckets Aggravated by humid weather conditions	Use only clean mixing pails and tools. Avoid excessive standing of mixed materials.
Putrefaction	Same as for Settling Condition	Same as above.
Excessive Shrinkage	Excessive amount of mixing water. Especially prevalent when cold water and cold cement are used	Use 60° F. water and follow manufacturer's instructions
Edge Cracking	Thick coats of cement under the tape and fast drying conditions.	Avoid application over hot surfaces near pipes, radiators, salamanders. Control ventilation during the drying cycle in hot weather so as not to obtain radical changes in temperature. avoid drafts.
Nails Photographing	Airborne soot or dust particles collecting over nailhead. Shank of nail will conduct cold; airborne particles collect over this cooler area.	Dependent upon cleanliness of air. Deposits can be washed off
Tape Photographing	Cement over tape is glazed due to tape being high. Deeper fills on either side of tape will not be glazed and will thus have a rougher texture.	Press tapes in tightly. A shear coat will equalize suction and texture.
Starved Joints	Delayed shrinkage (not allowing preceding coats to dry). Insufficient cement applied over tape to fill recess. Over sanding.	Allow sufficient drying time between coats of cement. Keep sanding to a minimum.
Blisters in Tape	Insufficient cement under the tape. Tape not initially pressed into good contact with cement.	Open up blister by slitting tape. Fill cut with cement and press tape back in place.
Poor Bond	Freezing of wet cement in pail or on wall after application. Insufficient soaking time.	Protect from freezing. Allow necessary soaking time.
Cracks in Inside	Too much cement over the tape at apex of angle	Wipe down corners correctly, leaving only a small amount or no cement in the apex.
"Burn Thru" or Joints Showing Thru Paint "Bleeding Thru" "Showing Thru"	1. Painting before the joint system is completely dry. 2. Crowning the joints will cause a difference in light reflection. 3. Difference in texture and suction between cement and board 4. Painting with paint having poor hiding properties — thinning paint too much (Same is true for textures, as well as paints.)	1. Allow sufficient drying time 2. Avoid high crowns 3. Apply primer or skim coat 4. Avoid excessive thinning of paints.
Beading	Movement of the board or uneven shrinkage	Bring adjacent boards into same plane with a shear coat before taping. Be sure board is tight to framing.
Nail Popping	Shrinkage of lumber or loose board	Allow framing to dry as much as possible. Draw board up tight to framing without crushing core or cutting paper



JOINT SYSTEM PRODUCTS

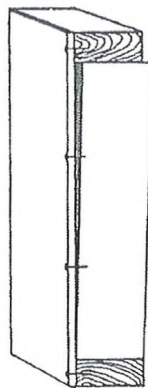
GENERAL SALES DATA

Advantages of G-P Joint System Products

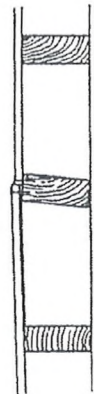
Advantages	Description
Mixing	Competitive products must be mixed very stiff initially, whereas Georgia-Pacific products are mixed at about the consistency they will be used.
Stability	After mixing our products stiffen, whereas competitive products thin out. This is particularly true in warm weather.
Plasticity	Our products have, in general, more plasticity than competitive products. Plasticity enables better control in applying our products, with both hand application and Ames tools. This means better shearing and feathering qualities.
Durability	Our products develop greater strength and water resistance over a period of time. After 30 days standing competitive products turn mushy when re-wetted, while our products retain their strength because of their resistance to dampness and wetting.
Shrinkage	Our products have, in general, lower shrinkage than similar competitor products. G-P Topping has lower shrinkage than any other casein based compound.
Quality	According to management, Georgia-Pacific Gypsum Division joint system sales have increased greatly while complaints have decreased. This is a strong indication of high quality standards.

Common Causes of "Nail Pops."

UN-EVEN
TOP PLATE

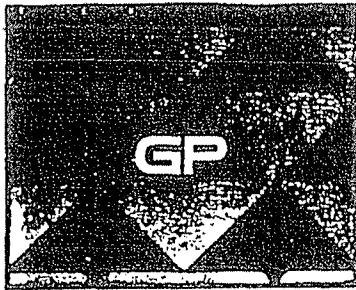


TWISTED
STUD



STUD NOT
ALIGNED





JOINT SYSTEM PRODUCTS

GENERAL SALES DATA

JOINT SYSTEM DRYING TIME

Temperature and humidity have a direct effect on the drying time of joint treatment products. While there is very little that can be done to alter temperature and humidity under job conditions, care should be taken to note the average differences in drying times under different atmospheric conditions, so that problems may be minimized. Joint treatment products must be thoroughly dry before successive coats are applied, and/or final decoration is applied. In all cases, a well ventilated area assists in the proper drying of these materials.

The chart shown below indicates the average drying periods for joint treatment products under different temperature and humidity conditions.

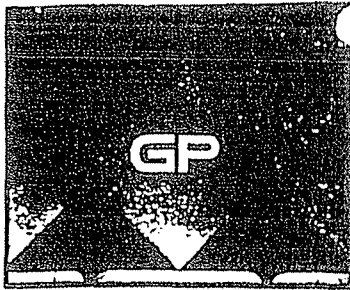
Relative Humidity	0	20%	40%	50%	60%	70%	80%	90%	98%
Temperature ° F.									
40	28 H	34 H	44 H	2 D	2½ D	3½ D	4½ D	9 D	37 D
60	13 H	16 H	20 H	24 H	29 H	38 H	2½ D	4½ D	18 D
80	6 H	8 H	10 H	12 H	13½ H	19½ H	27 H	49 H	9 D
100	3 H	4 H	5 H	6 H	8 H	10 H	14 H	26 H	5 D

H = hours

D = days

(24 hours)

It is extremely important that the difference in absorption between the wallboard surface and the compound over joints and nails be equalized to assume uniformity of color, suction and texture over the entire wall or ceiling. After the joint treatment has been completed and thoroughly dried, the surfaces should be sealed or primed with a vinyl or oil base primer/sealer.



JOINT SYSTEM PRODUCTS

PRICING SHEET

PRODUCT	PACKING	PRICE		
Triple Duty Wallboard Joint Compound	25 lb. bags			
	50 lb. bags			
Bedding Compound	25 lb. bags			
Topping Compound	25 lb. bags			
All Purpose Joint Compound	25 lb. bags			
	18 lb. bag with 250' roll of tape			
	6—5 lb. boxes to case			
Ready Mix Joint Compound	4—1 gal. pails to case			
	5 gal. pails			
Speed Set Joint Compound	25 lb. bags			
Bestex™ A	25 lb. bags			
Bestex™ B	40 lb. bags			
Bestex™ C	40 lb. bags			
Bestex™ D	40 lb. bags			
Joint System Packages Package No. 1, 18 lbs. Finisher, 250 ft. Tape	Single bags			
Package No. 2, 4 lbs. Finisher, 60 ft. Tape	6 Packages to case			
Patching Plaster	6—5 lb. boxes to case			

CAM 000994

